Item ID: Revision ID:	D209-669-04	3			<u>-</u>	Accept	*/	1900	0040	100)*	Setup Sta	ırt *N	S1*
	Replacement S	kidtube						, me				Ste	op *N	C2 *
Start Date: Required Date: Reference:	29/05/2012 16/07/2012	Start Qt Req'd Q	-		*1* *1*			Cust Ițem Customer:						. 12
Approvals:	Process Plan	n: ML	J	Date:	2/05/29	Tooling:		D	Pate:		j	Run Sta	I/J	R1*
1 .	QC:			Date:_		SPC (Y/N):		. D)ate:		:	Sto	^{эр} *N	R2*
Sequence ID/ Work Center II		Operation Description				Set Up/ Run Hours	· <u>*</u>	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr												
D2906	Rev	В		•		•		•						
100		DOCUMEN	VŢ CONTRO	DL .		0.00								
DC Document Control			Memo Photocopy I	D209-669 bl	uefile & type lal	0.00 bels per PPP D205-669	9-043 Chg (ous per	GCA 12	-599				
110		· •				0.00		·	; • .			*		
110 .		Skidtubes	.,	. •		0.00		i,						
Skidtubes		,	Memo - Inspect ma	nt'l D2500-1	-190 for damag				CA	- /	2.6-1	<i>.</i>		
•	* *		-Drill pilot h cutting fluid	noles using o	lrill jig DT8149,	, DT8711-2 & DT871	1-3 (Do not i	use	ر ازد.	·				
						6 without cutting fluid		SA	<u> </u>	W-0	6-11		÷	r v
			-Deburr and	blow out al	l chips from			•			,			1
			-Acid etch a	nd Alodine	tube per QSI 00	5 4.1 - >	F	12	9-6-11	٠.			,·	

Dart Aerospace Ltd

w/0:عر	892	WORK ORDER CHA	WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
						·						
<u>. </u>				,`								

Part No: 1209-669-013 PAR #:	Fault Category: Skill whe	NCR: Yes No	DQA:	Date: <u>/2/07/2-7</u>
Resolution:	Disposition: We an in	QA: N/C Closed	d:	Date: 12 7 2

NCR: 12-	(626)	V	ORK OR	DER NON-CONFORMANC	E (NCR)			
DATE	STEP	Description of NC Section A	Corrective Action Section B Initial Action Description Sign & Date Chief Eng Chief Eng Date		Verification Section C	Approval Chief Eng	Approval QC inspector	
12/6/18	140	Tube is overbent. Sud: 2.20 AH= 4625 RC!	12/6/18	Acceptable.		SAD 12-06-18	12/6/18	(245) 18. 12. 12. 12. 12. 12. 12. 12. 12. 12. 12
		-						

84892

Page 2

May-29-12 2:42	7:18 PM			040	197						r age 2
Item ID: Revision ID: Item Name:	D209-669-04 Replacement S			Accept	*N900	040	100)* s	Setup Start Stop	171.	S1*
Start Date: Required Date: Reference:	29/05/2012 16/07/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	ID:				IV.	,
Approvals:	Process Pla	n:	Date:			ate:	·	Ą	Run Start Stop	*NI *NI	₹1* ₹2*
Sequence ID/ Work Center II 120 *120* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Qc7 Memo		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty		Reject Number	Insp. Stamp
*130 *130* Skidtubes Skidtubes		Pick: Qty Part Nui A/R Sikafl Sikaflex expir Start Time: Fin Time: pick: Qty I	mber Description Bat ex-291 M1214 e date: \3-4-12	189 1207-09	e cutting				Œ	12.6-	12

W/O:		WORK ORDER CH	IANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12.56-12	120	Change Giz to Qi7				-	:

Part No: _		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
	T	Description of NC		Corrective Action Section B	Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Item ID: Revision ID:	D209-669-0			Accept	*N900	1040	100)* s	Setup Start	ın.	S1*
Item Name: Start Date: Required Date Reference:	Replacement 29/05/2012 :: 16/07/2012 .	Start Qty: 1.00	*1* *1*		Cust Iten Custome				Stop	*N:	S2*
Approvals:		an:	•			Date:	- ·	F.	Run Start Stop	1/1	R1* R2*
Sequence ID/ Work Center I 140 *140* CNC Bend I CNC Delta 100 Be 150 *150* Skidtubes Skidtubes		2-Cut tubes Skidtubes Memo	er program COB43FWD as per Dwg. D2906	Set Up/ Run Hours 0.00 0.00 & COBRAFT on CNC Ber 0.00 0.00 m bending QS1002 and trim/ grind fl (se tube expander 1/2 x170 o achieve dwg dimention.			Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control		, QC5- Inspect part comple		0.00 0.00	- Lic 12 /	/07/ 0 9		,	D	BEH	p3/09

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W/O:		** · · · · · · · · · · · · · · · · · ·	V	ORK ORDER CHANGES	<u> </u>				- m (#
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	_ Disposit	sition: QA: N/C Closed: Date:					
NCR:		V	ORK OR	DER NON-CONFORMAN	CE (NCI	₹)	,		
DATE	STEP	Description of NC	In late 1	Corrective Action Section E	Sign (Verific		Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Date		on C	Chief Eng	QC Inspector:
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Page 4

May-29-12 2:47:18 PM Item ID:

D209-669-043

Accept

N900040100

Setup Start

Revision ID: Item Name:

Start Date:

Replacement Skidtube

29/05/2012 **Required Date:** 16/07/2012

Start Oty: 1.00 Reg'd Oty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Date: _____

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID Operation Description

Large Fab

Set Up/ **Run Hours** Tool ID

Tool # Plan

Accept Code Qty

Reject Qty

Reject

Insp. Number Stamp

170

Skidtubes

Skidtubes

170

Memo

0.00

0.00

-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper

not to hit web. Deburr

-Drill pilot holes for aft & fwd cap using DT8215 open holes to #6" Deburr

-Drill pilot holes for Tow ring using DT8091-3 , open to .640" and Deburr

DC 12/05/09

190

QC5- Inspect part completeness to step on W/O

Memo

Situation

QC

Quality Control

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DATE	STEP	PRO	OCEDURE CH			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		·								
Part No:		PAR #:	Fault Cat	egory:	NC	R: Yes	No DQ	A:	Date: _	
			Disposition: QA: N/C Closed: I						Date: _	
NCR:		,	WORK ORI	DER NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descrip	Section B	Sign & Date	2	cation ion C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 84892 May-29-12 2:47:18 PM			—	*848	392*	T T	· ·· — ·	T. 222. T.			
Item ID: Revision ID: Item Name:	D209-669-0			Accept	*N900	040	100)*	Setup	Start Stop	*N *N
Start Date: Required Date: Reference:	29/05/2012 16/07/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					
Approvals:	Process Pla	ın:	Date:	Tooling: SPC (Y/N):		nte:			Run	Start Stop	*N *N
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt	ject y	Reject Number
200 *200* HandFinish		Pressure Wash per QSI0	05 4.3	0.00						26	12-

210

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo
START TIME:
OVEN TEMPERATURE:
FINISH TIME:

0.00

Powdercoat

Hand Finishing

Powder Coating

220

220

Quality Control

QC3- Inspect Part Finish

Memo

0.00

Insp. Stamp

Page 5

0.00

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W/O:		(4 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 	WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAP	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:				R NON-CONFORM					-
		Description of NC			ion B	Verification		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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Page 6

May-29-12 2:47:18 PM Item ID: D209-669-043 Accept *N900040100* Setup Start **Revision ID:** Item Name: Replacement Skidtube **Start Date:** 29/05/2012 Start Qty: 1.00 Cust Item ID: Req'd Qty: 1.00 **Required Date:** 16/07/2012 **Customer:** Reference: Run **Process Plan:** Approvals: Date: **Tooling:** Date: OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool# Plan Reject Accept Reject Insp. Work Center ID Description Qty Qty Run Hours Code Number Stamp 230 0.00 HandFinishing *230* HandFinish 0.00 Memo Hand Finishing 1-Install inserts & wearplates as per Dwg. D2906. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 (2)130 Sikaflex expire date: 14/03 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2906 3-Inspect for foreign object per QSI 024 4-Install D2855 Fwd & Aft Cap as per Dwg D2906 and seal Fwd & Aft Cap with Sikaflex. Clean excess adhesive Sikaflex-291 _121/30 Sikaflex expire date: 14/03

5-Wing Walk as per Dwg D2906 and OSI 005 4.4

Batch: 122 310

	Johnson								
W/O:			W	ORK ORDER CHANGE	S				•
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
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DATE	STEP	Description of NC		Corrective Action Section B Initial Action Description			ation	Approval	Approval
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W	ork	O	rder	ID	84892
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260

260

Quality Control

Page 7

Insp.

May-29-12 2:47:18 PM D209-669-043 Item ID: Accept *N900040100* Setup Start **Revision ID:** Item Name: Replacement Skidtube **Start Date:** 29/05/2012 Start Qty: 1.00 **Cust Item ID: Required Date:** 16/07/2012 **Reg'd Qty:** 1.00 **Customer:** Reference: Run Date: ____ Tooling: Approvals: **Process Plan:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Reject Reject Accept **Work Center ID** Description Qty **Run Hours** Code Qty Number Stamp 240 QC5- Inspect part completeness to step on W/O *240* Memo Quality Control Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024 250 0.00 Packaging *250* Packaging 0.00 Memo Packaging Identify and pack for shipping as per PPPD209-669-043

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

M120713

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DATE	STEP	PRO	CEDURE CHAI	NGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:		_ NCF	R: Yes N	lo DQA	\	_ Date: _	· · · · · · · · · · · · · · · · · · ·
	R	esolution:	_ Disposition	າ:		_ QA:	N/C Clo	sed:		Date: _	
NCR:		W	ORK ORDE	ER NON-C	CONFORMA	ANCE	(NCR)			<u> </u>	
DATE	STEP	Description of NC		Corrective		on B	0:	Verifica	ation	Approval	Approval
	01.21	Section A	Initial Chief Eng	Action	Description Chief Eng		Sign & Date	Sectio	n C	Chief Eng	QC Inspector
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May-29-12 2:47:22 PM

Work Order ID: 84892

84892

Parent Item:

D209-669-043

D209-669-043

Parent Item Name:

Replacement Skidtube

Start Date: 29/05/2012

Required Date: 16/07/2012

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

new IPP 08.02.13 LL, verified by: DD

IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D4202-1		Manufactured	No				Each	81.0000		19		· . · · · · · · · · · · · · · · · · · ·
D4202-1									**	DC 12	187/0	
•				Location	B83263	Loc	<u>Qty</u>	Loc Code	(ia)			
				LG			5				-	
				LG002	77727		5				-	·
					78806		76 · 6		_		-	
					79810		70			.	-	•
D2500-1-190		Manufactured	No			110	Each	91.0000	-1	1	<i>^</i> _	
D2500-1- Ext'n -`I' Beam Tube 4"	190								**		_G	12-6-11
				Location		Loc	<u>Qty</u>	Loc Code				4
				HALL	24222		91				-	
					74777 800 <u>61</u>		14 77		_		-	!
D2926-3		Manufactured	No	•		110	Each	0.0000	1	1	- n	
D2926-3	•			B84	950		•		**		A	12.6-12
D2855		Manufactured	No			230	Each	21.0000	2	2		:
D2855			÷						**	2		12/07/10
				Location	0.15.~2	Loc		Loc Code		•	-	
				FP002	65519		21 2				-	
				4,	73347		16		_		- -	!
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W/O:			W	ORK ORDER CHANG	ES					,
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory:	NCR:	Yes N	o DQ	A:	Date: _	
	R	esolution:	Dispositi	on:	_ QA: N	VC Clos	sed:		Date: _	
NCR:		\	WORK ORE	DER NON-CONFORMA	ANCE (NCR)				
DATE	CTED	Description of NC			ion B		Verification		Approval	Approval
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Page 2

Work Order ID: 84892

Parent Item:

D209-669-043

Parent Item Name: Replacement Skidtube

84892

D209-669-043

Start Date: 29/05/2012

**

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-5A

Purchased

No

No

No

230

Each

1,090.000

AN3-5A

Location	<u>L</u>	oc Qty	Loc Code		
ST350		1090			
115371		46			
117423		124			
118626		31			
119355		200			
120187		500			
121185		189			
	230	Each	0.0000	4	4

AN960JD10L

NAS1149D0332J Furchased

*AN960.ID101 *

Washer

ALS7-1032-130

Purchased

121011

230

Each

2,136.000

**

**

44

ALS7-1032-130

Insert

Location		Loc Qty	Loc Code
ST280		51	
11771	17	27	
11896	56	22	
11977	15	2	
ST282		2085	
11953	30	73	
12018	31 /	12	
12144	14 /	2000	

	•								
W/O:			W	ORK ORDER CHANG	ES	11111			•
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:	
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NCR:		\	WORK ORD	ER NON-CONFORM	ANCE (NCR)		***	
DATE	STEP	Description of NC			tion B	Verification App			Approval
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Work Order ID: 84892 *84892* Parent Item: D209-669-043 *D209-669-043* Parent Item Name: Replacement Skidtube **Start Date: 29/05/2012 Required Date: 16/07/2012** Start Qty: 1.00 Required Qty: 1.00 AN3C4A Purchased No 230 Each 1,458.000 *AN3C4A* ** Location Loc Qty Loc Code 122151 ST350 1458 120187 57 120521 28 120769 38 121205 1000 121556 335 NAS1149C0332 Purchased AN960C10L No 230 Each 0.0000 122063 *AN960C10I * ** washer D2594-3 230 Manufactured No Each 2,418.000 14 **

O-Ring, 205 Skidtube

Location	Loc Qty	Loc Code	
FP001	2418		
65518	41		
79496	984		
79573	50		
70755.	12/12		

Dail Aci	Ospace	Liu							
W/O:			WO	RK ORDER CHANGE	S				· 3
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA	·	_ Date: _	
	R	esolution:	Disposition	:	QA: N/C Cld	osed:		Date:	•
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC	Initial	Corrective Action Section	n B Sign &	Verifica		Approval	Approval
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May-29-12 2:47:22 PM

Work Order ID: 84892 *** ********************************	
Parent Item: D209-669-043 *D209-669-043*	
Parent Item Name: Replacement Skidtube Start Date: 29/05/2012	Required Date: 15/07/2012
Start Qty: 1.00	Required Qty: 1.00
D2594-1 Manufactured No 230 Each 311.0000 14 14	•
D2594-1 Plug, 205 Skidtube	D (2/07/11
Location Loc Oty Loc Code	1
FP001 8495) 98	
73401 30	
74442 18 79495 50	,
FP-A 213 73401 0	
78590 213	
D3564-9 Manufactured No 230 Each 22.0000 1 1	
D3564-9 Wearshoe ** / (JP 12/07/1)
Location Loc Qty Loc Code	
FG 84876 4	
76950 4	
FP001 18	
67590 4	1
69943	
82255 13	
D3564-11 Manufactured No 230 Each 8.0000 1 1	
D3564-11 Wearshoe **	P 12/07/11
<u>Loc Oty</u> <u>Loc Code</u>	
FG 3910 4	
77056 4	
FP001 4	
80341 4	

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DATE	STEP	PRO	CEDURE CH	RE CHANGE By Date Qty Chief En					
Part No);	PAR #:	Fault Cate	egory: N	CR: Yes	No DQ	A:	Date: _	
	R	esolution:	_ Disposition	on: Q	A: N/C CI	osed:		Date: _	
NCR:		W	ORK ORE	DER NON-CONFORMANC	E (NCF	R)	,		
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May-29-12 2:47:23 PM

Work Order ID: 84892		*84	1892	*							
Parent Item: D209-669-043				669-04	2*						
Parent Item Name: Replacement Skidtu	ıbe	1 7.	Z (1.51=	()():7-()4)			tart Date: 29 Start Qty: 1.			Date: 16/07/2012 d Qty: 1.00
*D3564-5 *D3564-5* Wearshoe	Manufactured	No			230	Each	13.0000	1 **	1		12/07/11
			Location FG FP001	84869 V 34806 77609 82254	<u>Lo</u>	2 2 11 3 8	<u>Loc Code</u>			 	
*D3566-1 *D3566-1* Gasket	Manufactured	No			230	Each	31.0000	2 **	2	0	12/07/11
			Location FP FP002	81619 68924 80919 83898	<u>Lo</u>	-22 10 53 2	Loc Code				
D3566-5 *D3566-5* Gasket	Manufactured	No		63676	230	16° Each	21.0000	l ★★	1		12/07/11
			FP FP002	82275 80374 82274 84 89	<u>Lo</u>	12 12 12 9 3 6	Loc Code				

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W/O:		-	W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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5.477		Description of NC		Corrective Action Section	on B		Verific	ation	Approval	Approval
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QTY	QTY	Part Number	D. a. da da
		Part Number	Description
-041	-043		
X	L	D2906-041	SKIDTUBE ASSEMBLY
	X	D2906-043	SKIDTUBE ASSEMBLY
11	1	D2500-1-190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1		D2926-1	WEB
	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1		D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1		D3566-15	GASKET
50	44	ALS7-1032-130	INSERT
1		or AKS7-1032-130	
1		or AKS4-1032-130	
<u></u>		or ALS4-1032-130	·
50	44	AN3C4A	BOLT
4	4	AN3-5A	BOLT
50	44	AN960C10L	WASHER
4	4	AN960JD10L	WASHER

GENERAL NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.

3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.

4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.

5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.

S) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.

7) WELDING TO BE DONE PER DART QSI 004.

8) FINISH:

ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

 INSERT D2594-1 PLUG CW D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).

10) ALL DIMENSIONS ARE IN INCHES.

RELEASED

L.,								
В	ADD S CHANG PG 1: A PG 2 C PG 3 C	TAINLESS STE SE WEARPLAT ADD NOTE 10; 7: REMOVE A 3: CORRECTE	FORMAT; RE-ORGANIZE; EEL WEARPLATES AND GASKETS TE HARDWARE TO SS; FT Ø0.640 HOLE FROM -041; ED -043 CAP P/N; WAS 44 PLACES;	СВ	07.08.21			
Α	NEW IS	SSUE		CP	04.06.22			
REV.			DESCRIPTION	10,110				
DESIGN P								
DESIGN		q)	DART AEROSP	ACE	LTD			
DESIGN DRAWN		CB	DART AEROSPA HAWKESBURY, ONTARI	ACE O, CANA	LTD DA			
	.D	CB BH.	DART AEROSPA HAWKESBURY, ONTARI DRAWING NO.	ACE O, CANA	LTD ADA REV. B			
DRAWN		CB OH GH	HAWKESBURY, ONTARI	O, CANA	\DA			
DRAWN CHECKE	PR.	CB CH CH AR	DRAWING NO. D2906 TITLE	O, CANA	REV. B			
DRAWN CHECKE MFG. AP	PR. /ED	CB CH CH AS	DRAWING NO. D2906	O, CANA	REV. B SHEET 1 OF 3			

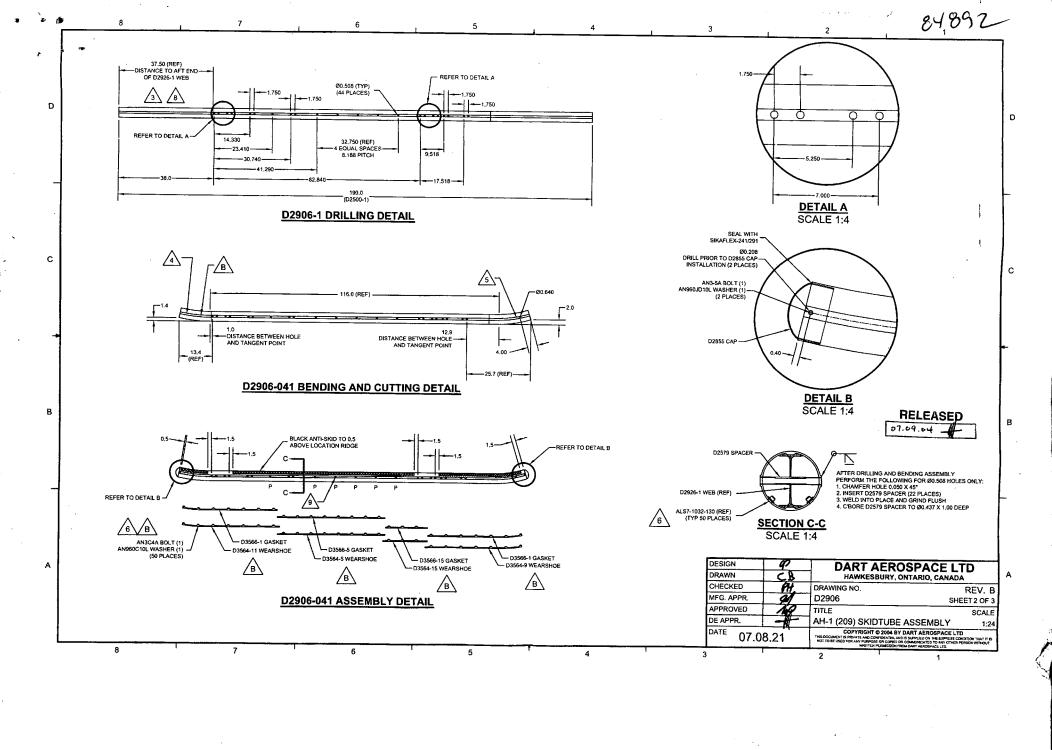
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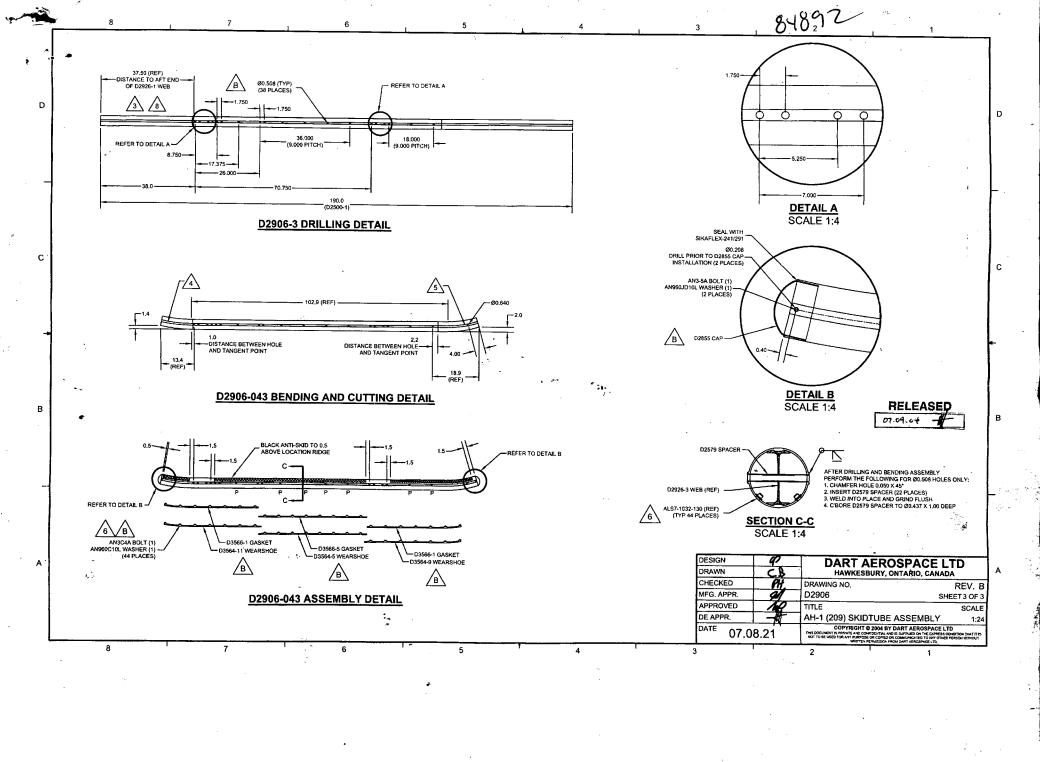
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NOTE: Date & initial all entries

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Dart Aerospace Ltd W/O: **WORK ORDER CHANGES Approval Approval** DATE **STEP PROCEDURE CHANGE** By Date Qty-Chief Eng / QC Inspector Prod Mar PAR #: _____ Fault Category: ____ NCR: Yes No DQA: ____ Date: _____ Disposition: _____ QA: N/C Closed: ____ Resolution: Date: WORK ORDER NON-CONFORMANCE (NCR) article . NCR: Description of NC **Corrective Action** Section B Verification Approval **Approval** STEP DATE **Action Description** Sign & Section A Initial Section C Chief Eng QC Inspector Chief-Eng Date -Chief Eng